

**SUBSTITUTE  
SPECIFICATION**

**ABSTRACT**

An inner hole [[31]] to which a driving shaft [[2]] is inserted is formed in a cam piece [[3]] of a camshaft [[1]], and a plurality of grooves [[34]] extending in the insertion direction of the driving shaft [[2]] are formed in the inner hole [[31]]. The driving shaft [[2]] is inserted into the inner hole [[31]] with the cam piece [[3]] heated to expand the diameter of the inner hole [[31]]. By reducing again the diameter of the inner hole [[31]] by cooling it in this state, an outer circumferential surface of the driving shaft [[2]] is pressed and raised by the inner hole [[31]] and enters the groove [[34]], by which the cam piece [[3]] is firmly fixed onto the driving shaft [[2]].